inspect label

Quality Control

NCR: \	es / No				WORK ORDER NON-C		NFORN	AANCE / UP		QA Closed:	Date:	•
NA/ or with Country					DISPOSITION			-	AGAINST DE	PARTMENT	PROCESS	15
Work Orde Part N NCR N	No				Rework Scrap Use-as-is Work Order Update		ſ	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup								:				
Other												
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Supplier	_											
Training	_					1			*			·
Unapproved		<u> </u>										
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Landir	ng Gear			_	General		,			_		•
]	Bending			<u> </u>	Bend	L	Grain		<u> </u>	Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (D/S	BOM/Route	\perp	Hardwa	re		Over/Under	tolerance	Temperature/Cure
*	Cracks			<u> </u>	Broken/Damaged		Inspecti	on incomplete		Part Incorre	ct	Weld
	Crushed/Crimped.				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
}	Cuffs			<u> </u>	Contamination		Mainte	nance	9	Part Moved		÷
1	Heat Trea			<u> </u>	Countersink	L	Mislabe	led	8	Positioned V	Vrong	•
[Cut Too Short		Misread	f		Power Loss/	Surge	Other	
1	Ripples in			<u> </u>	Drill Holes	Ŀ	Offset					
	Torque W		xtrusion	' <u> </u> _	Drawing	Out of Calibration						
	Turning Sequence				Finish	1	Out of 9	equence				

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Work Orde November-30-12				*94	207*				Pa	age 2
Revision ID:	D350-607-5			Accept	*N90004	1 0100*	Setup	Start Stop	*NS1 *NS2	*
	11/30/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				IV.72	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1 *NR2	*
Sequence ID/ Work Center ID 120 *120 *120 CQC Quality Control		Operation Description QC4- 100% Inspect kits f	for completeness	Set Up/ Run Hours 0.00 Si 0.00 J		ol# Plan Acce Code Qty	ept Re Qt	•	Reject Insp. Number Stam	
130 *130* Packaging Packaging		Pick Kit Memo Package as p	er PPPD350-607-543	0.00	102	i i i i i i i i i i i i i i i i i i i	1 5	Z (12/12/19	SD
140 *140* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00			<u> [r</u>	2/12	z/20C	8

N (2-20-12)

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Work Orde	ar.					DISPOSITION				AGAINST I	ΣEÍ	PARTMENT	PROCESS		*
WOIK OIGE	· –	<u> </u>				Rework	1		Skid-tube	Crosstube	\neg		Water Je	t∏	Engineering
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, arer	_		**			Use-as-is	1 1		noforming	Finishing	\neg	ł	e/Packaging	-	Other
NCR N	١o.					Work Order Update	1		Large Fab	Composite	\neg		Supplie	-	
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Root					Descri	ption of work order update	1	Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	\sqcup	Date	Verification	on	QC Inspector
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		entre No	t Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa			_	Over/Under		<u>_</u>	Temperature/Cure
		racks				Broken/Damaged	\vdash	1	ion Incomplete		—	Part Incorre		—	Weld
		rushed/0	Crimped.		_	Burrs		1	tions Incomplete/	/Unclear		Part Lost/M	issing		Wrong Stock Pulled
	C	uffs			1	Contamination	1	Mainte	enance		,	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

November-30-12 10:11:03 AM

Work Order ID:

94207

Parent Item:

D350-607-543

Parent Item Name:

Heli-Utility-Basket

Start Date: 11/30/12

Required Date: 12/14/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
20=00 74310 [Manufactured	No				Each	4.0000	G.	2050			
uick Release Basket Mo	unting Installation			*		1 04		C-1-	·) 1-3-0	J.S	- 2	
	^			Location		Loc Oty	<u>.</u>	Loc Code					
\prec	<i>(</i>)			PK012	.40	4							
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myara Assembly				Location		Loc Qty	<u> </u>	Loc Code					
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				ST014		27						4	
				90:	568	. 2							
				910	542	1							
				925	559	4			92	739			
				927		6							
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19192011		Manufactured	No				Each	3.0000			V. A		
yebolt Receiver Assemb	ly										- 79		
\sim				Location		Loc Qty	<u>]</u>	Loc Code			•		
2111				ST072		3							
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¥1030±043		Manufactured	No	~			Each	0.0000	/2				اميا
ong Basket Assembly, L	ight Lid (350)									197 D	90	1'	414

NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPD	DATE			
									1		QA Closed:	Date:	•
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Root						ption of work order update		nitial	Acti		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				÷									
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General		_				<u> </u>	_
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat				o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Grain Ovalized Hardware Over/Under tolerance Inspection Incomplete Part Incorrect Instructions Incomplete/Unclear Part Lost/Missing Maintenance Part Moved Mislabeled Positioned Wrong				ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Inspection Strip in Tube			Tube	<u> </u>	Cut Too Short	L	Misread	d	Power Loss/Surge Other			
		Rinnles in	Kend		1	Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Order ID:	94207									
· Parent Item:	D350-607-543						Start Date	e: 11/30/12	Required Date:	12/14/12
Parent Item Name:	Heli-Utility-Basket						Start Qty	: 1.00	Required Qty:	1.00
D-1005-5		Manufactured	No			Each	12.0000	(1)	76	19
Placard, Instructions					3				- 1B	
5m)				Location	Loc Qty		Loc Code		U	
ンMっ				ST093	1					1
				87037	1					
				ST095	11			4 5 7 70		
				87738	11			87738		
Placard, Max Load		Manufactured	No			Each	12.0000	\	7/18	SR
Flacard, Max Load									- yD	/
5m				Location	Loc Oty		Loc Code		•	
<i>J</i> 111				ST093 87674	12					
_		•		90185	10			90185		
Missill		Manufactured	No			Each	8.0000		0 /	
Basket Fwd Hardpoint A	ssembly, Lower								1- 1B	
				Location	Loc Oty		Loc Code	,		•
Sm	`			ST101	8					
-1.12				89111	5			89/11		
				91839	2					
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D4151043 Basket Fwd Hardpoint A	ocombly Unner	Manufactured	No			Each	9.0000	94251	28	17.1/2/11
basket rwu Hatupoliit A	ssemoly, Opper	•								12/19.11
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				92741	8					
					•					190

											DQA:	Date	
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											QA Closed:	Date	:
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						Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	Vo.					Work Order Update	_		Large Fab	Composite	j	Supplier	
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Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
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1	Bending					Bend	<u> </u>	Grain		_	Ovalized	<u> </u>	Pressure/Forced
191	Centre Not Concentric to O/S				o/s	BOM/Route	_	Hardwa		<u> </u>	Over/Unde	 	Temperature/Cure
	Cracks				<u> </u>	Broken/Damaged		- i	on Incomplete		Part Incorre	}	Weld
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	Inspection Strip in Tube					Cut Too Short		Misread	i		Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Work Order ID:

94207

Parent Item:

David - 041

D350-607-543

Parent Item Name:

Attachment Arm Assembly

Heli-Utility-Basket

Manufactured No **Start Date:** 11/30/12

15.0000

Required Date: 12/14/12

Start Qty: 1.00

Required Qty: 1.00

<u>Location</u>	Loc Qty	Loc Code
ST100	15	
89232	3	
90848	2	
92513	1	
92683	4	
93281	5	
	Γ-	

Bolt

Purchased

Purchased

No

No

Each 669.0000

Each



Location		Loc Qty	Loc Code
FG		20	
	122808	20	
GA		1	
	121652	1	
Return201	2	8	
	122416	8	
ST356		640	
	120187	19	
	120770	12	
	122063	1	
	122416	10	
	122808	2	

420

176

Each

19.0000



Location Loc Qty Loc Code ST357 19 120124

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NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP				
											QA Closed:	Date	
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NCR N	lo.					Work Order Update	ال		Large Fab	Composite		Supplier	
Root Cause		Date	Step	Qty	1	ption of work order update or Non-conformance		Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
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		Bending				Bend	Г	Grain			Ovalized		Pressure/Forced
	_	_	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Centre Not Concentric to O/S Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld	
Crushed/Crimped.			Burrs		4 '	tions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
Cuffs			Contamination		Mainte			Part Moved	_				
Heat Treat			Countersink		Mislabe	eled		Positioned V	Wrong	<u></u>			
`		Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
Torque Waves in Extrusion				n 🗀	Drawing		Out of (Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Work Order ID:

94207

Parent item:

D350-607-543

Parent Item Name:

Heli-Utility-Basket

Purchased

Start Date: 11/30/12

Start Qty: 1.00

Required Date: 12/14/12

Required Qty: 1.00

PIN, QUICK RELEASE

Nut

Cotter Pin

Purchased

Purchased

Purchased

No

No

No

No

Location

ST343

Location

Location ST314

ST331

114340

118612 123346

119017 122452

123021

123248

123355

Loc Qty

95

1

1

13

50

30

9.0000 Each

Loc Code

95.0000

Loc Code

Loc Qty 2 6

Loc Qty

4165 20

184

1461

900

1600

Each

Each

Each

4,165.0000

Loc Code

12302

22800

Location Loc Qty Loc Code ST323 223

149 122802 74 17566

223.0000

22802

									DQA:	Date: _	
NCR: Yes	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	•
Work Order:		<u></u> -			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	\$
Part No.	·	111			Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
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Inapproved	1		1	1							

FAULT CATEGORY

Landi	ng (Gear	General		_	
		Bending	Bend	Grain	Ovalized	Pressure/Forced
		Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
		Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
		Crushed/Crimped_	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
		Cuffs	Contamination	Maintenance	Part Moved	
		Heat Treat	Countersink	Mislabeled	Positioned Wrong	 _
		Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
		Ripples in Bend	Drill Holes	Offset		
		Torque Waves in Extrusion	Drawing	Out of Calibration		
		Turning Sequence	Finish	Out of Sequence		
		Wave/Twist in Tube	Folio	Outside Dimensions		

Work Order ID:

94207

Parent'Item:

D350-607-543

Parent Item Name:

Heli-Utility-Basket

Start Date: 11/30/12

Required Date: 12/14/12

Start Qty: 1.00

Required Qty: 1.00

arent Item Name:	Hen-Utility-Basket							Start Qt	y: 1.00	Kequirea Qi	y: 1.00
ASHER .		Purchased	No				Each	365.0000		2 J B	
				Location	!	Loc Qty		Loc Code			
_ ^				FG	W.	8					
5m)					103691	8					
				ST298		357					
					118709	2			_		
					120390	105			12039	0	
i.					123560	250					Λ.
AS1149FU432P	_	Purchased	No				Each	186.0000		12	
Vasher		rarenasea								1 pB	
			,	Location	1	Loc Qty		Loc Code		,	
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					121330	13				•	
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Vasher		ruichaseu						,,		13	12/0/11
danci						F Ot .		L. C. J.		0	
^				Location	Ī	Loc Qty		Loc Code			
2m/2				ST292		1031				-	
<i></i>					115358	1				-	
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400

200

123248 123355

							DQA: _	Date: _	٠
s / No			WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE					•
•			DISPOSITION			•			
).).			Rework Scrap Use-as-is Work Order Update	- 1	~ —	Crosstube Small Fab Finishing Composite			Engineering Quality Other
			Description of work order update	Initial	Act	tion	Sign &		
Date	Step	Qty	or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
	: D D	: D	:	DISPOSITION Rework Scrap Use-as-is Work Order Update Description of work order update	DISPOSITION Rework Scrap Use-as-is Work Order Update Description of work order update Initial	DISPOSITION Rework Skid-tube Machining Thermoforming Large Fab Description of work order update Initial Act	DISPOSITION Rework Skid-tube Crosstube Machining Small Fab Use-as-is Work Order Update Large Fab Composite Description of work order update Initial Action	WORK ORDER NON-CONFORMANCE / UPDATE OA Closed: DISPOSITION Rework Scrap Use-as-is Work Order Update Description of work order update Description of work order update OA Closed: AGAINST DEPARTMENT/ Skid-tube Machining Small Fab Finishing Composite Composite Description of work order update Description of work order update Description of work order update	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: DISPOSITION Rework Scrap Machining Machi

Bend Grain Ovalized Pressure/Forced Bending BOM/Route Hardware Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Cracks Broken/Damaged Weld Inspection Incomplete Part Incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Mislabeled Heat Treat Countersink Positioned Wrong Inspection Strip in Tube **Cut Too Short** Misread Power Loss/Surge Other Drill Holes Ripples in Bend Offset Out of Calibration **Torque Waves in Extrusion** Drawing Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio **Outside Dimensions**

FAULT CATEGORY

General

Process
Supplier
Training
Unapproved

Landing Gear

REFERENCE ONLY SIM

DART AEROSPACE LTD.

D350-607-3 Page 17 of 19

4.0 WEIGHT AND BALANCE

Installation	Weight	LA	TERAL	LONGITUDINAL		
		Arm	Moment	Arm	Moment	
D350-607-541	80.7 lb	± 49.1 in	± 3962 in-lb	135 in	10895 in-lb	
(Standard Basket)	36.6 kg	± 1.25 m	± 45.8 m-kg	3.43 m	125.5 m-kg	
D350-607-543	65.7 lb	± 49.1 in	± 3226 in-lb	135 in	8870 in- l b	
(Lightweight Basket)	29.8 kg	± 1.25 m	± 37.3 m-kg	3.43 m	102.2 m-kg	
D350-607-545	58.7 lb	± 49.1 in	± 2882 in-lb	135 in	7925 in-lb	
(Standard Basket)	26.2 kg	± 1.25m	± 32.8 m-kg	3.43 m	89.9 m-kg	
D350-607-547	47.7 lb	± 49.1 in	± 2342 in-lb	135 in	6440 in-lb	
(Lightweight Basket)	21.6 kg	± 1.25 m	± 27.0 m-kg	3.43 m	74.1 m-kg	
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg	

5.0 PARTS LIST

QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-541	-543	7-545	-547	-511	-501		
X		س				D350-607-541	HELI-UTILITY-BASKET
	Х					D350-607-543	HELI-UTILITY-BASKET
		Х				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	<u>4</u>	==1==	=1=	=x=		D350-607-511	QUICK:RELEASE:BASKET.MOUNTING:KIT
					Х	D350-607-501	CONVERSION KIT
		1			1	-D2690-6	-LANYARD
1	4=				4	D3910-3	X-TUBE LUG
				4	<u>4</u> 1		TEYEBOLT RECEIVER ASSY
1						-D3912-041	RUBBER EXTRUSION, X-TUBE
				8	- 8	D3984-030	LONG BASKET ASSY
1						D4030-041	
	<u>=1=</u>				===	:D4030:043:	L'ONG BASKET ASSY LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
11	<u> </u>	=1=	=		==1==	:D4085-3	=PLACARD=INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	41==				1_	:D4086-215	-PLAGARD, MAXILOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	-1-		=1=		1	:D4150-041	-AT-TACHMENT-ARM ASSY
1	<u>-1</u>	1==		==	1	-D4151-041	-BASKET-FWD-HARDPOINT-ASSY (LOWER).
1	41=	=1=	i ii		1	-D4151-043	BASKET: FWD: HARDPOINT ASSY (UPPER)
6	6 6	==6==	-6-		6-	AN4-13A	BOLT
				16	16	AN4-14A	BOLT
1	e1===		1			AN4C15	BOLT
 	<u>a</u> =					-AN310C4	-CASTELLATED NUT
	e1==	1-	1		1	-MS17984=C413	QUICK RELEASE PIN
6	6-		-6=	16=	22	-MS21042L4	INUT-(OR-MS21042-4)
1	\$ -1	1_1_			1	-MS24665-151	COTTER PIN
2	47	2=	=2=		-2-	-NAS1515H4L	-WASHER
	6 12	-12=	=12-	-32-	44-	NAS1149F0432P	-WASHER *
12 3	3	3		32	3	NAS1149F0463R	:WASHER?
3	3	3	3-			- NCO+02K	-AAUOI-ICI V

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